

Work Order ID 55068



Page 1

January 5, 2010 2:40:09 PM

Item ID: D3594-044

Accept



Setup Start



Revision ID:

Item Name: Floor Doubler Assembly, RH *10*

Stop



Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: 10-1-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



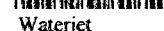
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
----------	--------------	--	--	--	--	--	--	--	--

D3594	Rev B								
-------	-------	--	--	--	--	--	--	--	--

100 *0.00*

100	FLOW WATER JET								
-----	----------------	--	--	--	--	--	--	--	--



Waterjet

Memo

0.00

B 10-1-7

100	FLOW CNC Waterjet								
-----	-------------------	--	--	--	--	--	--	--	--

FLOW CNC Waterjet

Memo
1-Cut as per Dwg D3594 Dwg Rev: *B* Prog Rev: *B* 02-
Deburr if necessary

21

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--



QC

Memo

0.00

B 10-1-7

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

Quality Control

120	QC8- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--



QC

Memo

0.00

→ S1010108

*counter
x20*

120	QC8- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--

Quality Control

PTD →

W/O: 55068

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/08	# 120	Took Qty +1 for QC inspection template	S	10/1/08	X1	U	S 10/1/08

Part No: D3594-044 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55068



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Page 2

Item ID: D3594-044

Accept



Setup

Start



Revision ID:

Item Name: Floor Doubler Assembly, RH

Stop



Start Date: 05/01/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Small Fab

Small Fab

0.00

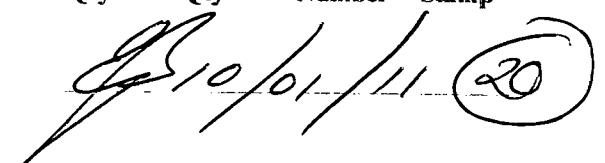
Small Fab

Memo

0.00

Small Fab

CSINK AS PER DWG D3594


10/01/11 (20)

140



QC5- Inspect part completeness to step on W/O

0.00

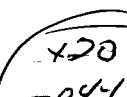

10/01/11

QC

Memo

0.00

Quality Control


X20
-041

150



Chemical Conversion Coat per QSI005 4.1

0.00


10-01-12

HandFinish

Memo

0.00

Hand Finishing


(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 55068

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January 5, 2010 2:40:09 PM

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Setup

Start



Revision ID:

Item Name: Floor Doubler Assembly, RH

Stop



Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



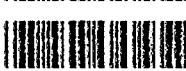
QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

M

10-01-12

X20

0

170



Small Fab

0.00

EP 10/01/13 20

Small Fab

Memo

0.00

Small Fab

Install Nut Plates As per Dwg D3594

180



QC5- Inspect part completeness to step on W/O

0.00

0.00

→ 10-01-13

QC

Quality Control

cancel
10-01-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55068

Page 4

January 5, 2010 2:40:10 PM

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Revision ID:

Item Name: Floor Doubler Assembly, RH

Stop



Start Date: 05/01/2010 Start Qty: 6.00



Customer ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 2:40:14 PM

Page 1

Work Order ID: 55068



Parent Item: D3594-044



Parent Item Name: Floor Doubler Assembly, RH

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item #	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	-----------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20426AD4-4

Purchased

No

100

Each

2,667.000

12.0000

Barcode

EP 01/01/13

Rivet

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Main Warehouse

ST

2667

15541

2667

M6061T6S.080

Purchased

No

170

sf

275.3809

3.2211

Barcode

*40
30*

AB (0-1-7)

6061-T6 .080 Sheet

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Main Warehouse

MAT

275.38087

110630

33.5136

112141

0.86727

113438

241

113438

61

MS21069-5

Purchased

No

170

Each

12.0000

6.0000

Barcode

EP 10/01/13

Anchor nuts

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Main Warehouse

ST

12

111310

12

M113627 (20x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	55068
Description: Floor Doubler, RH	Part Number:	D3594-4
Inspection Dwg: D3594	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 10-1-7	Date: 10/06/02	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue P/O D3594-044	KJ/JLM	
B	09.05.07	Dimensions updated per Dwg Rev B	KJ/EC	M

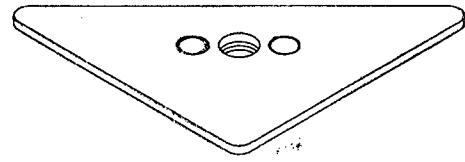
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

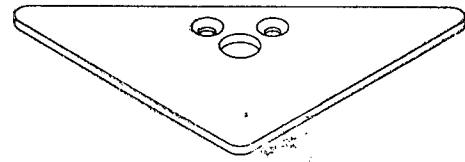
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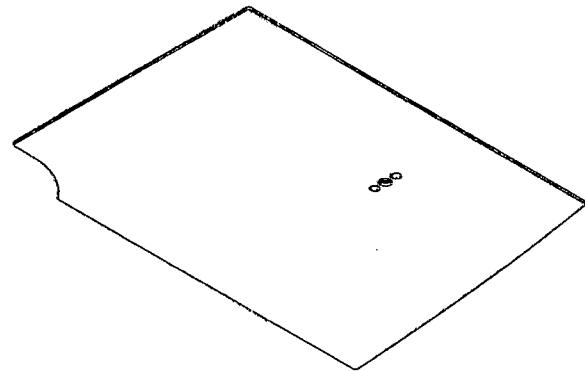
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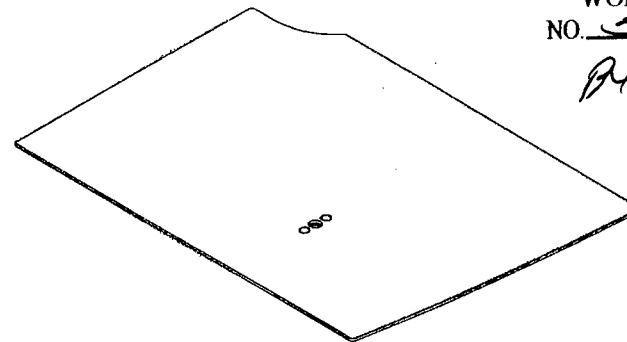
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55068

01/10-1-05

RELEASED
06.06.26.17

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD 5.			AJS	QB/05/14
A	NEW ISSUE			MB	07/04/13
REV.	DESCRIPTION			BY	DATE
DESIGN	M2	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. B		
MFG. APPR.		D3594	SHEET 1 OF 4		
APPROVED		TITLE	SCHE		
DE APPR.		DOUBLER	WTS		
DATE	06.05.14			COPYRIGHT © 2013 DART AEROSPACE LTD. THIS DOCUMENT IS PROPRIETARY AND IS SUBJECT TO EXPORT CONTROL LAWS. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN APPROVAL FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

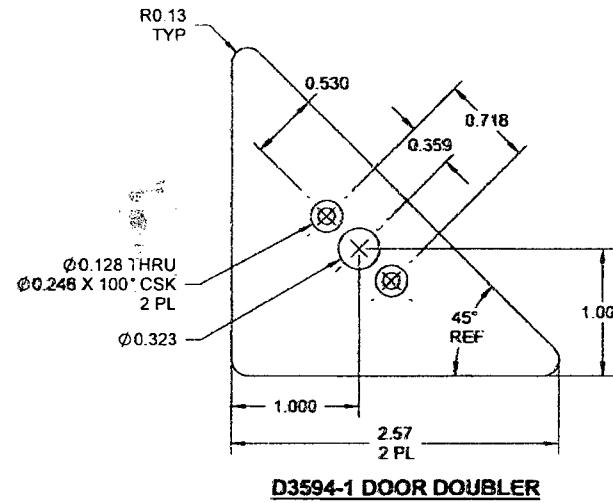
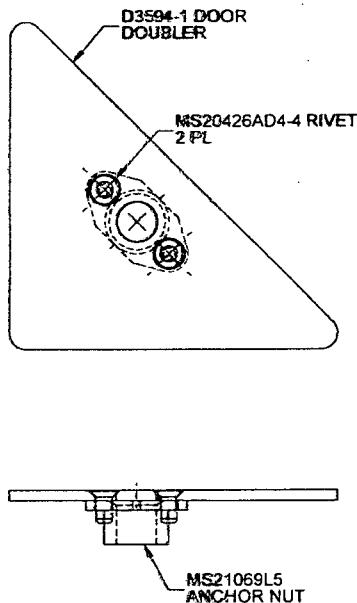
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

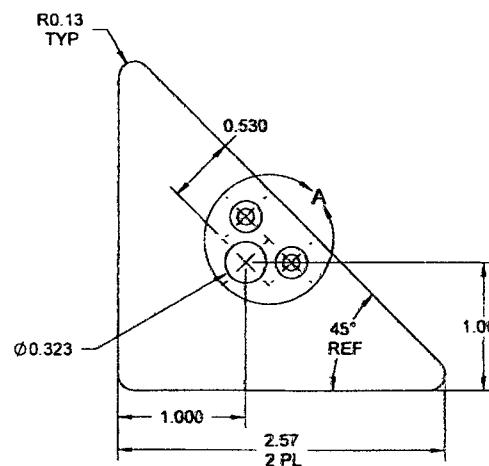
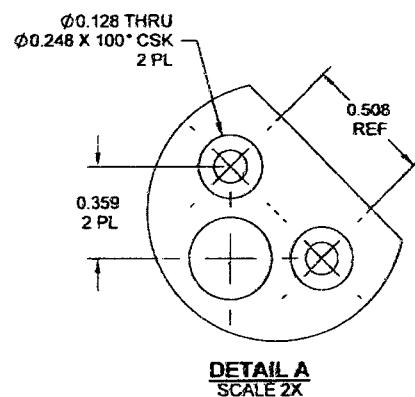
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



D3594-1 DOOR DOUBLER



D3594-5 DOOR DOUBLER

RELEASED
08-06-26/14
W/0 55068

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. B	
APPROVED		D3594	
DE APPR.		SHEET 2 OF 4	
DATE	08.05.14	TITLE DOUBLER	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

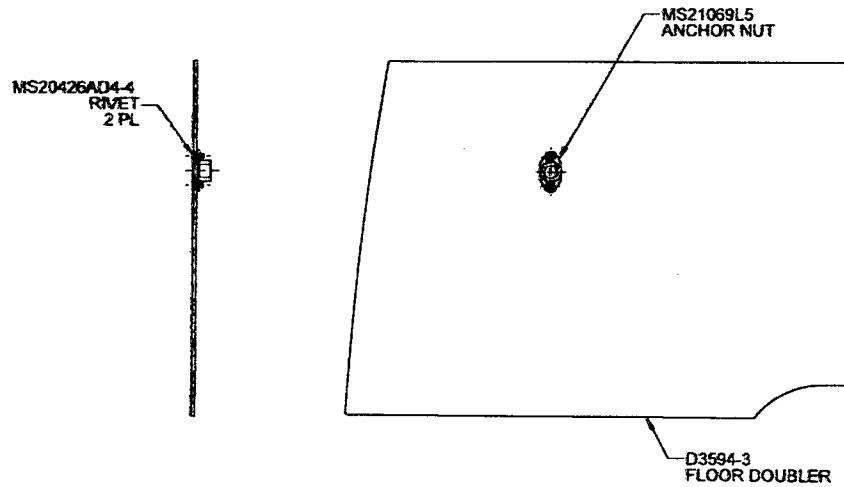
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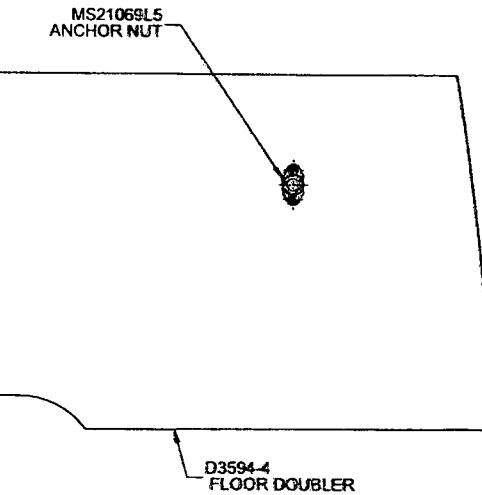
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY. 043	QTY. 044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
X		D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
1		D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. MS061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

w/0 55068

08.05.14

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	AS	D3594	SHEET 3 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	DOUBLER	INTS
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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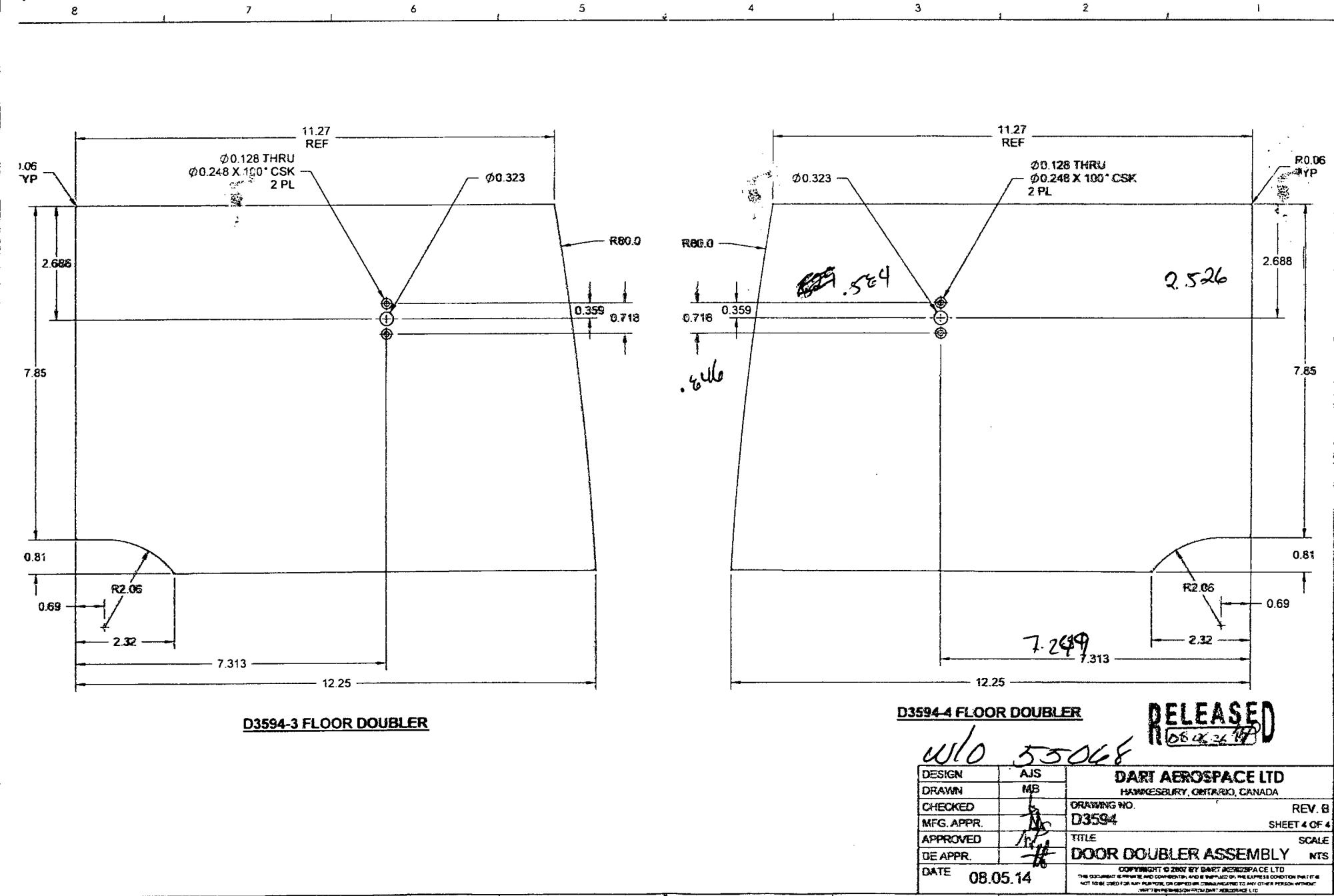
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CHECKED		DRAWING NO.	
MFG. APPR.		REV. B	
APPROVED		D3594	
DE APPR.		SHEET 4 OF 4	
DATE	08.05.14	TITLE	
		DOOR DOUBLER ASSEMBLY	
		NTS	

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107 .664 .161

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